

Work Order ID 68851

Page 1

Thursday, April 21, 2011 12:35:33 PM

Item ID: D3574-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *M* Date: 4-21-11

Tooling:

Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary B11-4-26 (4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

 B11-4-26

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

 8/16/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68851

Page 2

Thursday, April 21, 2011 12:35:34 PM

Item ID: D3574-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

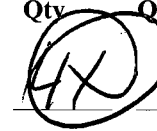
Memo

0.00

Small Fab

Debur if necessary.

⇒ m-l 11/04/27



140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Suloxbz

150

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

11/4/27 (4) sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68851

Thursday, April 21, 2011 12:35:34 PM



Page 3

Item ID: D3574-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27
MF
11-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:35:30 PM

Page 1

Work Order ID: 68851

Parent Item: D3574-1

Parent Item Name: Cabin Floor Protector



Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

sf

2,384.215

134.4672



B11-4-26

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

2384.215789

115261

367

116236

2017.21579

116236

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48851
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	x		V B62	
7.37	+/-0.030	7.37	x		T B01	
10.75	+/-0.030	10.75	x		T 1	
11.00	+/-0.030	11.00	x		T	
15.25	+/-0.030	15.25	x		T	
25.87	+/-0.030	25.87	x		T	
39.75	+/-0.030	39.75	x		T	
44.75	+/-0.030	44.75	x		T	
49.11	+/-0.030	49.11	x		T	
51.11	+/-0.030	51.11	x		T	
53.51	+/-0.030	53.51	x		T	
63.50	+/-0.030	63.50	x		T	
65.25	+/-0.030	65.25	x		T	
10.75	+/-0.030	10.75	x		T	
11.06	+/-0.030	11.06	x		T	
14.75	+/-0.030	14.75	x		T	
25.50	+/-0.030	25.50	x		T	
25.75	+/-0.030	25.75	x		T	
26.00	+/-0.030	26.00	x		T	
32.87	+/-0.030	32.87	x		T	
38.81	+/-0.030	38.81	x		T	
44.75	+/-0.030	44.75	x		T	
45.00	+/-0.030	45.00	x		T	
48.25	+/-0.030	48.25	x		T	
58.38	+/-0.030	58.38	x		T	
61.25	+/-0.030	61.25	x		T	
64.13	+/-0.030	64.13	x		T	
64.63	+/-0.030	64.63	x		T	
66.50	+/-0.030	66.50	x		T	
7.50	+/-0.030	7.50	x		T	
9.50	+/-0.030	9.50	x		T	
10.38	+/-0.030	10.38	x		T	
10.88	+/-0.030	10.88	x		T	
14.50	+/-0.030	14.50	x		T	

DART AEROSPACE LTD		Work Order:	68851
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	*		T	
18.75	+/-0.030	18.75	q		T	
24.13	+/-0.030	24.13	q		T	
26.50	+/-0.030	26.50	x		T	
30.50	+/-0.030	30.50	q		T	
33.88	+/-0.030	33.88	q		T	
39.50	+/-0.030	39.50	q		T	
40.25	+/-0.030	40.25	q		T	
43.50	+/-0.030	43.50	q		T	
43.83	+/-0.030	43.83	q		T	
46.60	+/-0.030	46.60	q		T	
7.63	+/-0.030	7.63	q		T	
11.00	+/-0.030	11.00	q		T	
11.50	+/-0.030	11.50	q		T	
16.75	+/-0.030	16.75	q		T	
19.00	+/-0.030	19.00	q		T	
22.50	+/-0.030	22.50	q		T	
30.75	+/-0.030	30.75	q		T	
32.63	+/-0.030	32.63	q		T	
32.75	+/-0.030	32.75	q		T	
35.13	+/-0.030	35.13	q		T	
36.50	+/-0.030	36.50	q		T	
40.00	+/-0.030	40.00	q		T	
41.88	+/-0.030	41.88	q		T	
43.63	+/-0.030	43.63	q		T	
0.125	+/-0.010	.130	q		V B02	

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-24	Date: 11/04/24	Date:	N/A

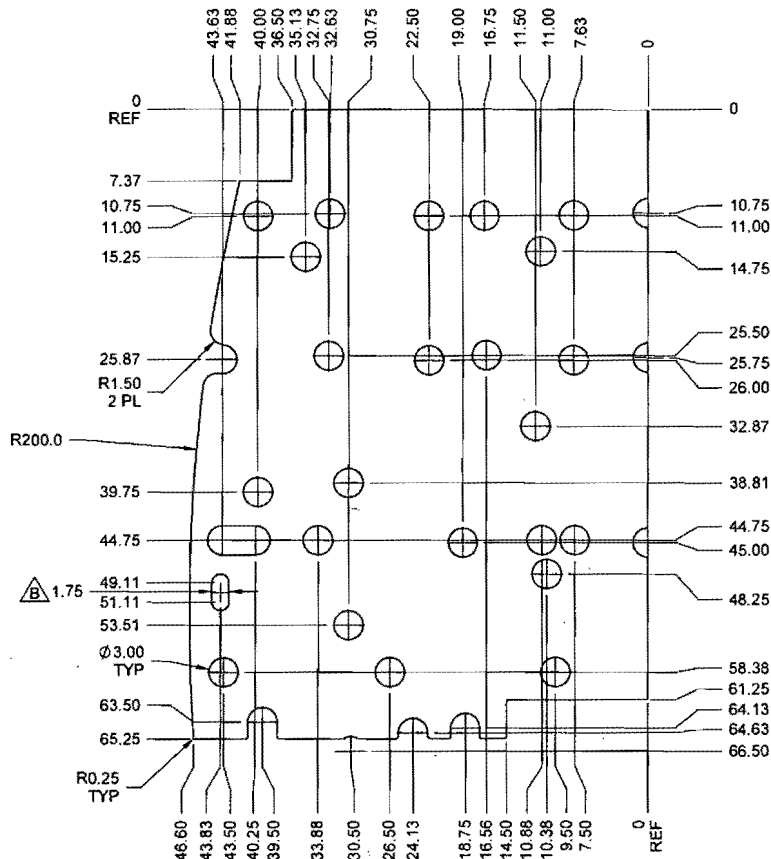
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 1068851
P11-0721



RELEASED
01/01/07



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN 87-1, 88-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	CB 07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

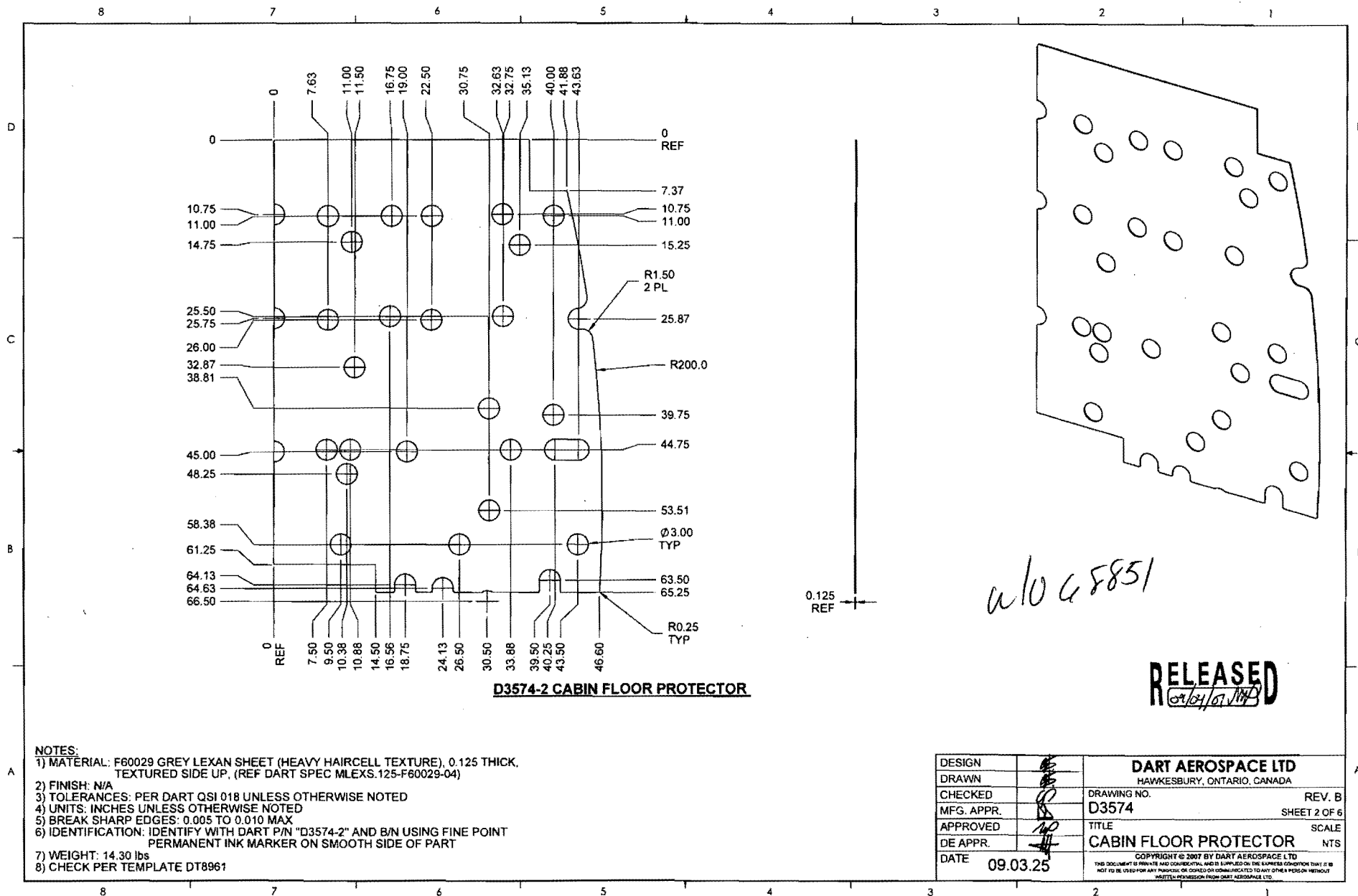
DRAWING NO.
D3574

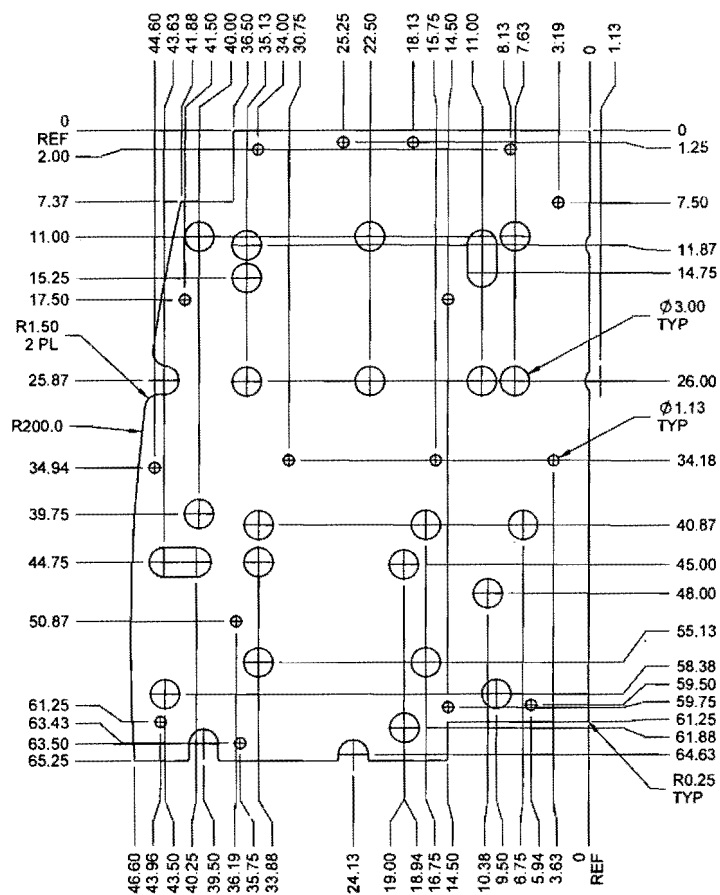
REV. B
SHEET 1 OF 6

TITLE
CABIN FLOOR PROTECTOR

SCALE
NTS

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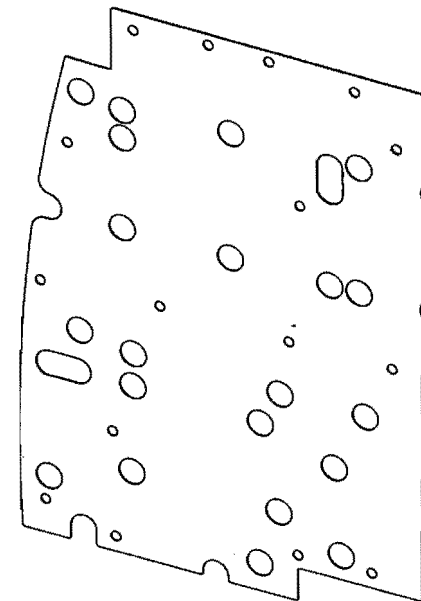




D3574-3 CABIN FLOOR PROTECTOR

NOTES:

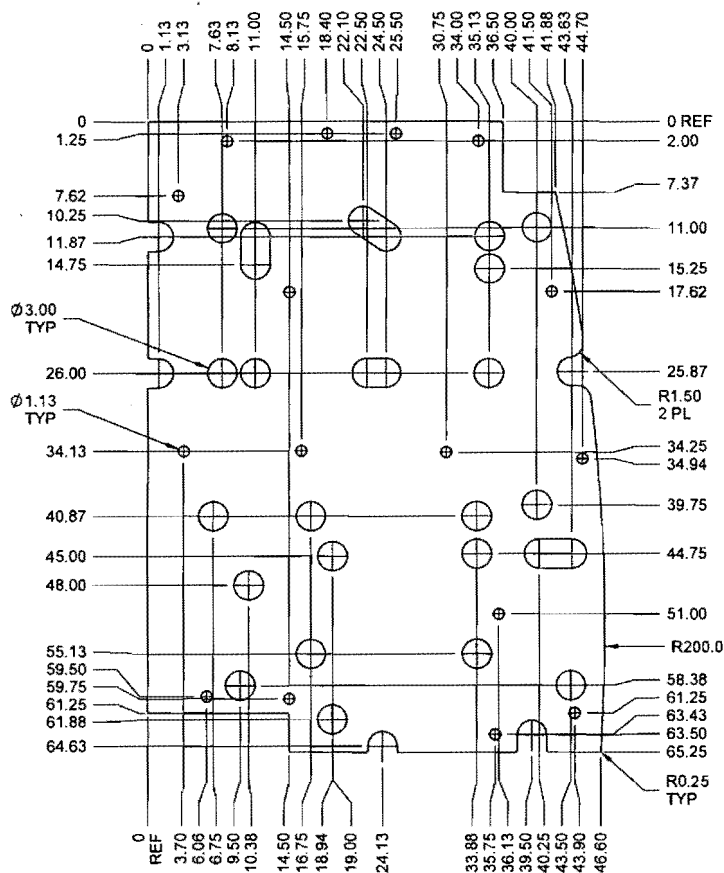
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962



W/068851

RELEASED
01/07/07

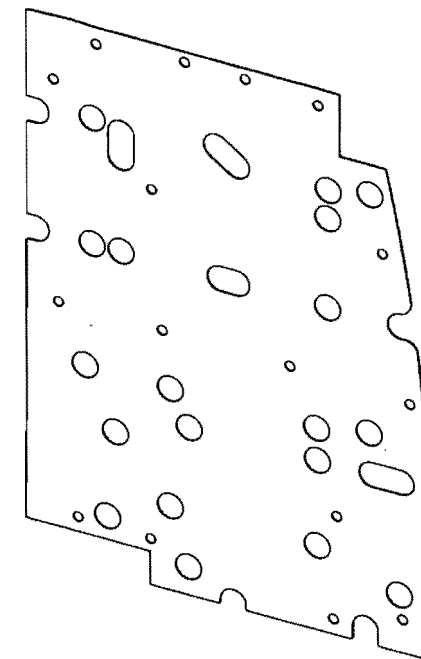
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.			SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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D3574-4 CABIN FLOOR PROTECTOR







NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXX.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963



W/068851

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 4 OF 6
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